

Date: Monday, 1/8/2007 10:53:23 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ASPIRATOR
<b>Job Number</b> : 30160	
<b>Estimate Number</b> : 10123	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D2060
<b>This Issue</b> : 1/8/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2060 REV. A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 1/30/2007 <b>Qty:</b> 50 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>[Signature]</i> 07.01.08	
<b>Comment</b> : Est: A 98.12.09 New Issue DM/KS	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0

PG

PURCHASING

**Comment:** PURCHASINGIssue P/O: 2829

Make per Dwg D2060

Possible Supplier: Sieg's Manufacturing

Material release note required

*C 207101/09*  
*(50)*

2.0

D2060P

Aspirator



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)  
 ASPIRATOR

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

*P27/1/17 50*

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK
*D207104/19 (50)*

5.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: 5213
*P27/1/22 50*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DP Date: 07/01/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 1/8/2007 10:53:23 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 30160

Part Number: D2060

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(50)

Comment: FINAL INSPECTION/W/O RELEASE

07/01/22

Job Completion



11 07.02.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

4.00 O'DIA

2.10 I'DIA

4.125

.84

1.312 I'DIA



MAT'L :  
.063 THICK  
1100 ALUMINUM

SHOE COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30160

REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 823		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
DRAWN			BASIC CODE	DIA. DASH NO. R-HEAD NEAR SIDE I-HEAD FAR SIDE	CONTRACT NO.		DART AERO ACCESSORIES INC. VANCOUVER CANADA		
APPROVED			D=DIMPLE DIGIT-NO OF SHEETS C-COUNTERSINK	LENGTH DASH NO. W=SPOTWELD	DATE 1992				
DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES		TITLE				
	GENERAL	LIMITS	BPMMS30410AD BPMMS20410AD		ASPIRATOR CORE				
	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125/ 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - S - 7742 5. HOLES PER AND 10087	1. TOLERANCES — .001 & .030 XXX & .010 2. ANGLES 5° & 90° 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005	CODE						
REPORT ALL DISCREPANCIES — DO NOT SCALE					CHECKED	DWC NO.		YSD 2060	
					CLIENT	SCALE		1:1	
							SHT. 1 OF 1		REV.

YSD 2060

A

*Sieg's Manufacturing Ltd.*

604 530-7455 fax 604 530-7490  
6236-205 Street, Langley, British Columbia, Canada. V2Y 1N7

# INSPECTION REPORT

DATE: Jan. 16/07

CUSTOMER: Dart Aerospace PO# 2820  
INVOICE #: 30910

INVOICE #: 30910 SUPPLIER #:

**DESCRIPTION OF INSPECTION:**

[illegible]

NOTES OF INSPECTION: Good

**NOTES OF REJECT:**



1480 Manheim Pike  
Lancaster Pa 17601

# Certification of Test Results

SOLD TO

COPPER & BRASS SALES INC  
22355 WEST ELEVEN MILE ROAD  
SOUTHFIELD, MI 48034

SHIP TO

COPPER & BRASS SALES INC  
6555 E. DAVIDSON  
DETROIT, MI 48212

CERT NO 0000598687  
DATE 10/26/2004  
SKID NO 322296  
SKID WGT 9,760  
PAGE 1 OF 1

ORDER NO	LB4176	PO NO	C99792			MILL FINISH NOT ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED
ITEM NO	1	PART NO	050393-8			
ALLOY	1100	TEMPER	O	FORM	COIL	
GAUGE	.06300	WIDTH	48.0000	LENGTH	0.0000	

LOT: 238066 COIL: B01 DROP: 440525

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
4405252	0.11	0.42	0.08	0.02	0.002	0.001	0.004	0.003	0.02

HEAD ULTIMATE STRENGTH 12.2 KSI  
TAIL ULTIMATE STRENGTH 12.6 KSI  
HEAD YIELD STRENGTH (OFFSET = .2%) 4.9 KSI  
TAIL YIELD STRENGTH (OFFSET = .2%) 5.6 KSI  
HEAD ELONGATION (G.L. = 2 IN) 35.5 %  
TAIL ELONGATION (G.L. = 2 IN) 33.5 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-04  
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:  
ASME SB209 1100 O, AMS 4001H 1100 O,  
ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL  
\*\* END OF CERTIFICATION \*\*

*Handwritten:*  
Haw  
Henry @ SHS  
C/O  
Sorel  
UTS

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.

Authorized By:

JBFF READY, LAB SUPERVISOR

5033320835

Slaps

3-24-05 3:56PM Copper & Brass Sales